

Date: Tuesday, 3/11/2008 7:57:11 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HINGE BRACKET  
Job Number : 37739  
Estimate Number : 10224  
P.O. Number :  
This Issue : 3/11/2008 S.O. No. :  
Prsht Rev. : NC Part Number : D2143  
First Issue : 1/1 Type : SMALL /MED FAB Drawing Number : D2143 REV. C1  
Previous Run : 34464 Drawing Revision : C1  
Material :  
Due Date : 3/31/2008 Qty: 20 Um: Each  
Written By :  
Checked & Approved By :  
Comment : Est C 00.05.18 Added inspection level 8 EC  
Est Rev:D Now on WaterJet 06-10-15 JLM

## Additional Product

Job Number:



Seq. # Machine-Or Operation: Description:

1.0 M5052H32S040 5052-H32 .040 Sheet



Comment: Qty.: 0.0693 sf(s)/Unit Total : 1.3860 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.040" thick

(M5052H32S.040)

Batch: 104921 IB 8-3-20

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2143

Dwg Rev: C1 IB 8-3-20

Prog Rev: C1

2-Deburr if necessary

SB

08/03/24

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

06-03-24 42 counted

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and Deburr

Done at step #22.

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 3/11/2008 7:57:11 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 37739

Part Number: D2143

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D2143

SB 08/03/25

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/25 (42) cont

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR 08-03-25 (42)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107005 (42)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BR 08/03/27 (42)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 198A

AS 08/03/28 (42)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/03

Job Completion



umf 08-03-28

W

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 37739
<b>Description:</b> Hinge Bracket		<b>Part Number:</b> D2143
<b>Inspection Dwg:</b> D2143	<b>Rev:</b> C1	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.340	+/-0.010	.340	*			
0.625	+/-0.010	.621	*			
1.000	+/-0.010	.999	*			
R0.063	+/-0.010	.063	*			
2.656	+/-0.010	2.653	*			
3.317	+/-0.010	3.300	*			
Ø0.257	+0.005/-0.000	.258	*			
Ø0.171	+0.005/-0.000	.173	*			
1.660	+/-0.010	1.661	*			
2.844	+/-0.010	2.844	*			
1.659	+/-0.010	1.660	*			
R0.125	+/-0.010	.125	*			
2.312	+/-0.010	2.311	*			

<b>Measured by:</b> AB	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-3-20	<b>Date:</b> 08-03-24	<b>Date:</b>	N/A

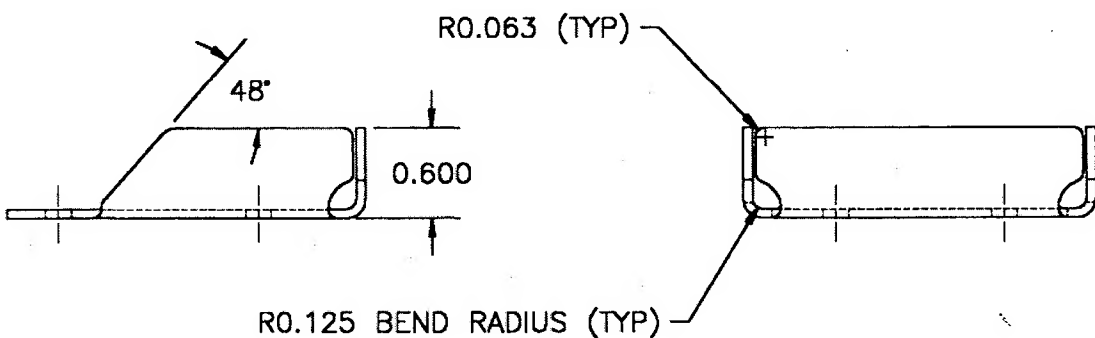
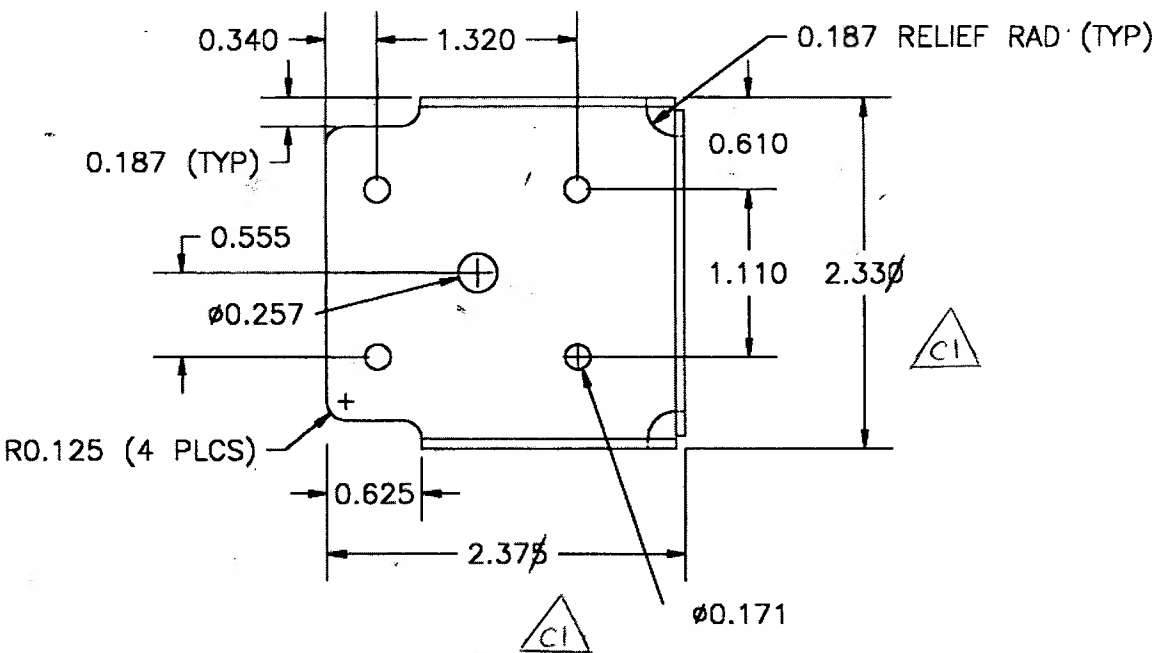
Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM	[Signature]

**DART**



**RELEASED**  
960626 BUS

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. C
J BRADLEY	K HAND	DRAWING NO. D2143	SHEET 1 OF 2
CHECKED B	APPROVED B	TITLE HINGE BRACKET	SCALE
DATE 92:07:10			
B	96.06.06	ADD FLAT PATTERN	
C	96.06.13	MATERIAL WAS 2024-T3 .063 THICK	
C1	4.06.15	UPDATE DIMENSIONS	



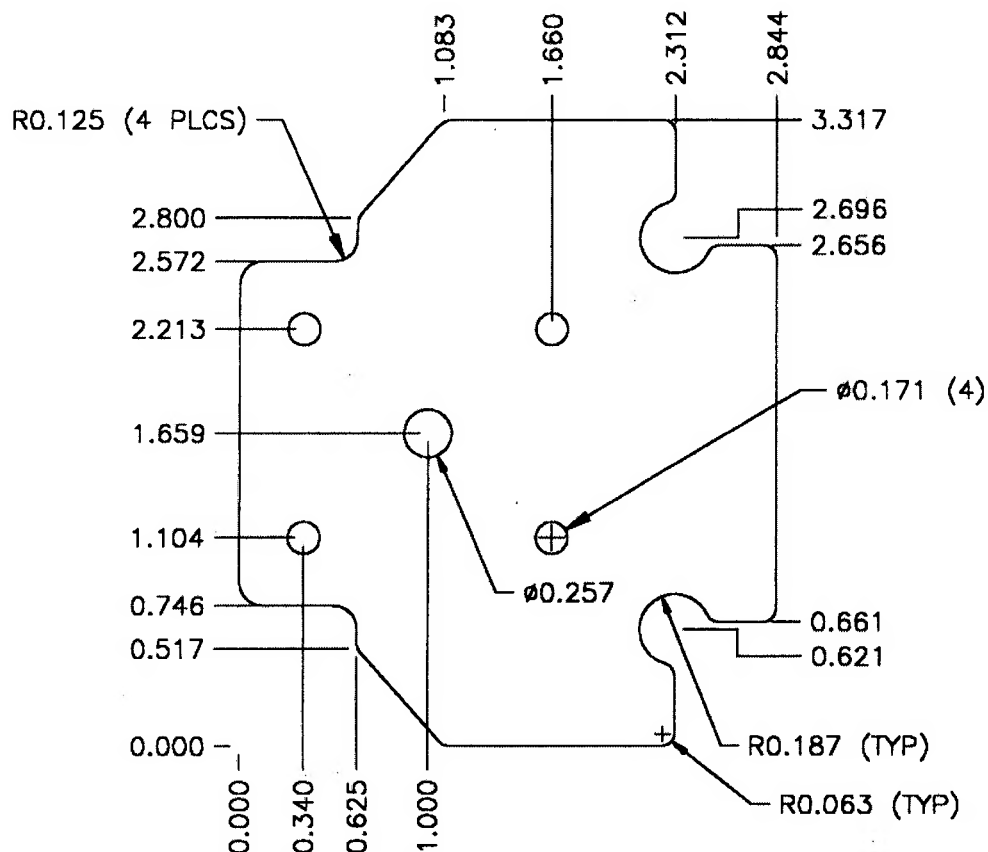
MATERIAL: 5052-H34, 0.040 THICK  
FINISH: WHITE POWDER COAT HI-GLOSS

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WITHOUT NOTICE  
WORK ORDER  
NO. 37239



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
J BRADLEY	K HAND	DRAWING NO.	REV. c
CHECKED	APPROVED	D2143	SHEET 2 OF 2
DATE		TITLE	SCALE
95:10:18		HINGE BRACKET FLAT PATTERN	1:1

RELEASED  
96 Gb 20 Bw



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WORK ORDER  
NO. 37739

MATERIAL: 5052-H34, 0.040 THICK GRAIN ALONG 3.317